

Date: Thursday, 04/09/2008 9:02:02 AM  
User: Julie Leacock

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 41797-1  
Estimate Number : 11403  
P.O. Number :  
This Issue : 04/09/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : SMALL /MED FAB  
Previous Run : 39871  
Written By :  
Checked & Approved By : JLD 08.9.04  
Comment : Est. C 05.10.14 Added step 14 KJ/EC  
Est Rev:D Revised Steps 06-11-20 JLM

Drawing Name : DOOR ASSEMBLY  
Part Number : D3296041  
Drawing Number : D3296 REV A  
Project Number : N/A  
Drawing Revision : A  
Material :  
Due Date : 11/09/2008 Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32961 Door Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Door Panel

Pick:

Qty Part Number Description Batch  
1 D3296-1 Door Panel 39744

2.0 D32963 Door Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Door Panel

Pick:

Qty Part Number Description Batch  
1 D3296-3 Door Panel 35233x2 39745x10

3.0 D31617 Hinge 14.0"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Hinge 14"

Batch:

341806x2  
B39891x10

4.0 D31619 Hinge 17.0"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Hinge 17"

Batch:

341807x3  
B32083x9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Thursday, 04/09/2008 9:02:02 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 41797

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS20470AD44

Rivet, Universal Head



Comp. + wait take at 15



Comment: Qty.: 25.0000 Each(s)/Unit Total: 300.0000 Each(s)

Rivet, Universal Head

Batch:

M107823 x157

all same Batch

JS 08/09/04 x12

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

FF 08/09/16

(8)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/16 x8

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:20AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:50AM

JS 08-09-17

(XP)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/09/17 (8X)

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Decal - No Step

Pick:

Qty

Part Number

Description

Batch

1

D2137

Decal

39139 x7 M108012 x5

JS 08/09/04 x12

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Handle

Pick:

Qty

Part Number

Description

Batch

1

D2419

Handle

41805 (5X)  
39881 x7

JS 08/09/04 x12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: DOOR ASSEMBLY

Job Number: 41797

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2462

Seal



Comment: Qty.: 0.3333 f(s)/Unit Total : 3.9996 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 4.00" LONG

37747

JS 08/09/04 12

13.0

D2462

Seal



Comment: Qty.: 0.4420 f(s)/Unit Total : 5.3040 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 5.30" LONG

37747

JS 08/09/04 12

14.0

D2462

Seal



Comment: Qty.: 2.0420 f(s)/Unit Total : 24.5040 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 24.50" LONG

37747

JS 08/09/04 12

15.0

D27281

Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

39012\*

JS 08/09/04 12

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

M6085

JS 08/09/04 12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: GU DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 41797

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet

ML68377

JS 08/09/04 12

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

FF 08/09/18

8

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/18 28

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 211

8/9/19

VS

SP

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/19 19

Job Completion



MF 08-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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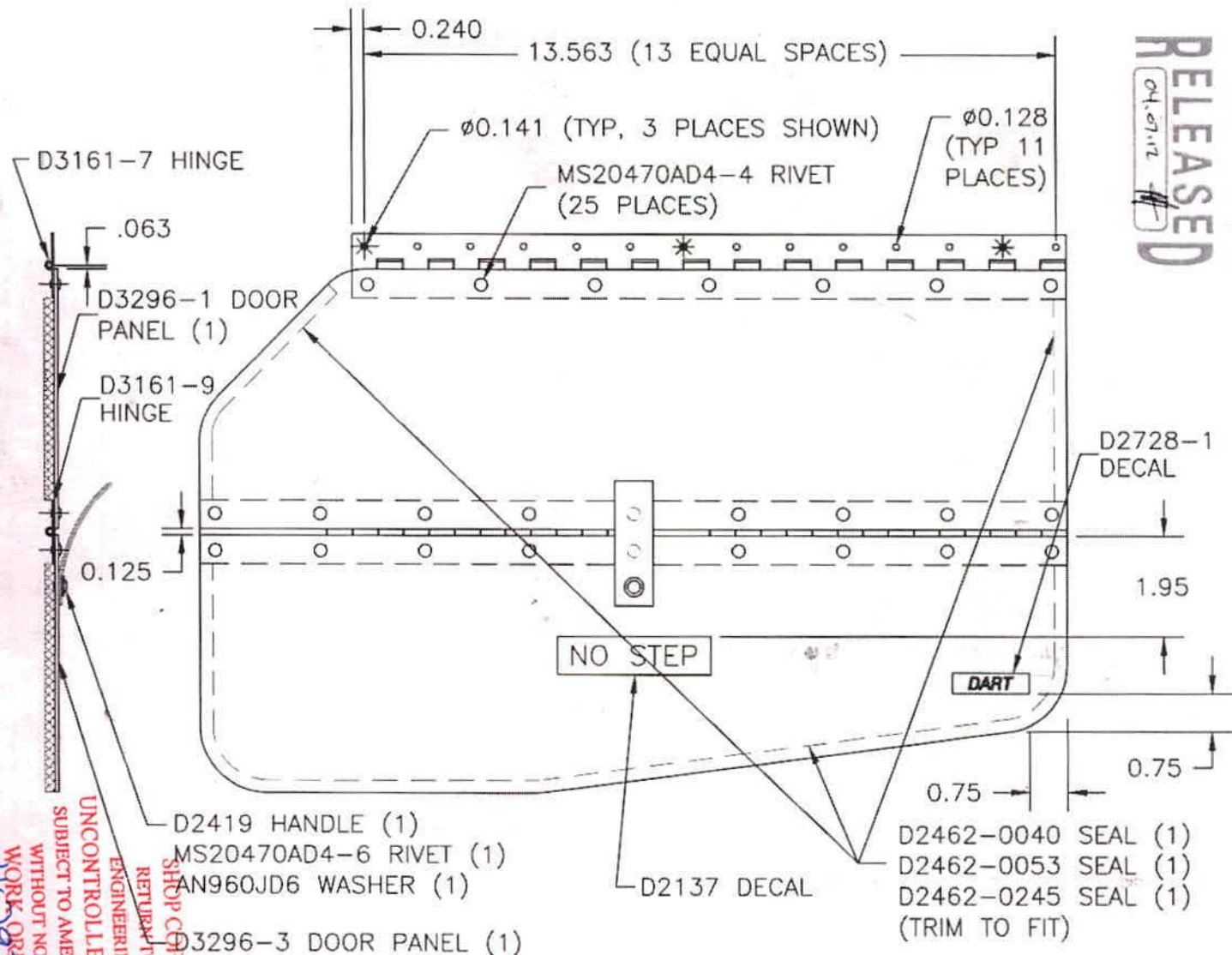
**NOTE:** Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296
DATE 04.06.28	TITLE DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	NEW ISSUE
		SCALE 1:3

RELEASED  
04.07.12



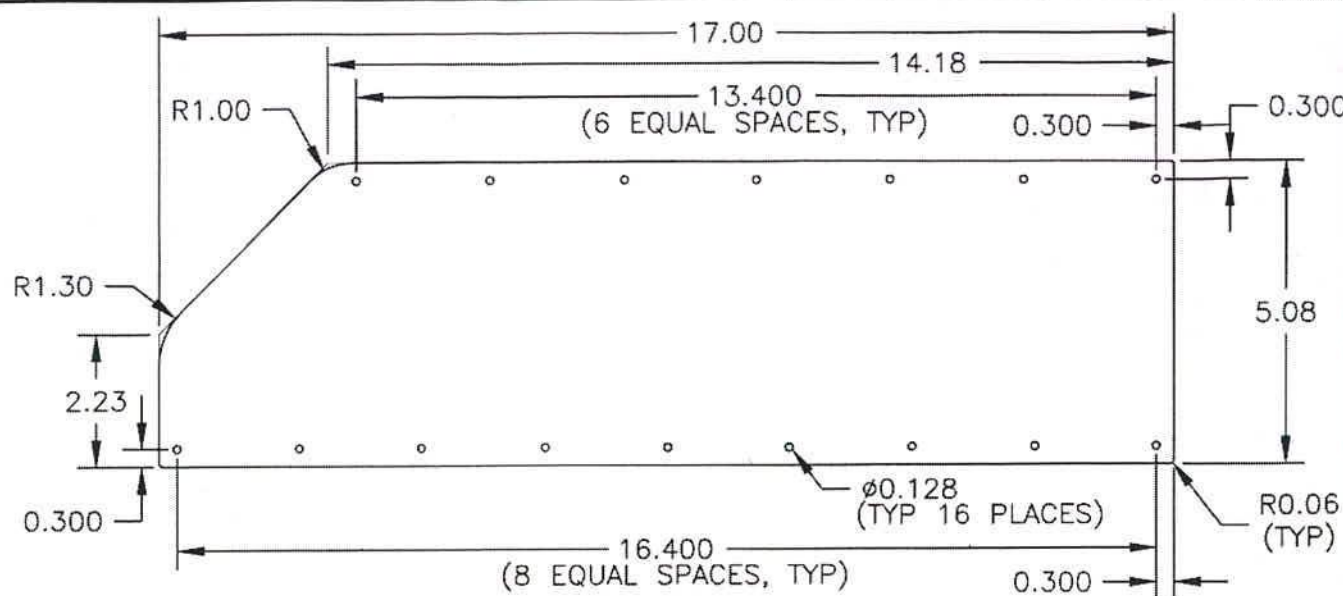
D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

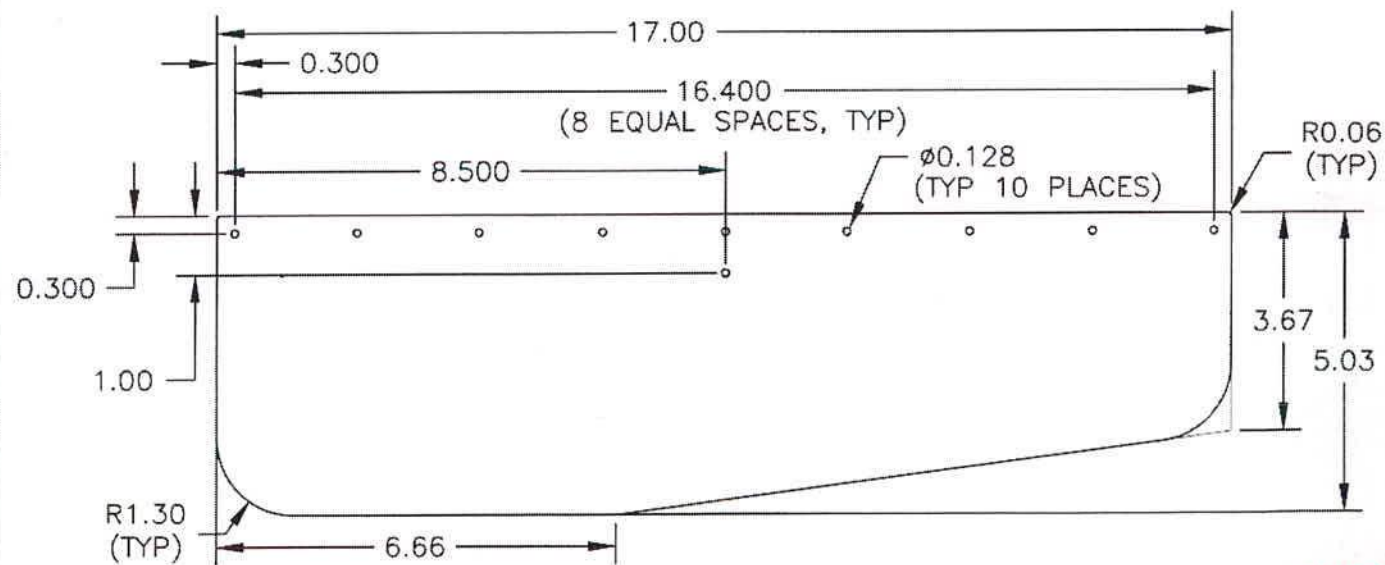
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41997  
RETURN TO  
ENGINEERING



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



**D3296-1 DOOR PANEL**



**D3296-3 DOOR PANEL**

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
04.07.12  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44787

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